

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021933**Date Inspected:** 18-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3019N

Weld No: 272

WR: 20407

Welder: 044779

WPS-345-SMAW-4G(4F)-FCM-Repair-1

PCMK: SEG-3019BB

Weld No: 181

Welder: 054013

WPS-B-P-2214-TC-U4b-FCM-1

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PCMK: SEG-3019BB
Weld No: 017
Welder: 216086
WPS-B-P-2212-TC-U4b-FCM-1

PCMK: SEG-3009U
Weld No: 003
CWR: 2822
Welder: 0215553
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: E2-SB31-001
Weld No: 015, and 016
Welder: 062092
WPS-2132-ESAB

PCMK: W2-SB18A-001
Weld No: 023 and 024
Welder: 048625
WPS-2132-ESAB

PCMK: W2-SB16B-001
Weld No: 013 and 014
Welder: 053742
WPS-2132-ESAB

PCMK: W5-SB30-004
Weld No: 011 and 012
Welder: 222396
WPS-2132-ESAB

Bay 19

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

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PCMK: SB26-001-110E

Weld No: 014

Welder: 259906

WPS-B-P-2211-U2-U4b

PCMK: SB26-001-110W

Weld No: 014

Welder: 259566

WPS-B-P-2211-U2-U4b

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SA-6030

Weld No: 6042A Surfacing

Welder: 062783

WPS-B-T-2131-ESAB

PCMK: SA-603

Weld No: 6043B Surfacing

Welder: 062749

WPS-B-T-2131-ESAB

PCMK: SA-6530

Weld No: 6550A Surfacing

Welder: 062306

WPS-B-T-2131-ESAB

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
